

Date: Monday, 05/03/2007 12:34:27 PM
 User: Linda Lacelle

Process Sheet

SPT/17-1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 30993
 Estimate Number : 10256
 P.O. Number : *N/A* Part Number : D22303
 This Issue : 05/03/2007 S.O. No. : *N/A* Drawing Number : D2230 REV F
 Preht Rev. : NC Project Number : N/A
 First Issue : 01/03/2007 Type : MACHINED PARTS Drawing Revision : F
 Previous Fun : 30545 Material : *N/A* Due Date : 03/12/2007 Qty: 1,000 Um: Each
 Written By : *ca*
 Checked & Approved By :
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

.0

D2423

Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 71.7150 f(s)

Lug Extrusion

D2423

Batch: *30062*

.0

BAND SAW

BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: _____

.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O *BLKT00001*

Possible Supplier : Metec

Machine per Drwg D2230 Rev. F

C207103108

7/2/10

1000

92

.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for transit damage

207/4/27

(220)

BAL178

Thursday, 3/1/2007 11:34:00 AM
Jim Johnston

Customer : CU-DAR001 Dart
 Job Number : 30993
 Estimate Number : 10256
 P.O. Number :
 This Issue : 3/1/2007
 Preht Rev. : NC
 First Issue : 1/1
 Previous Run : 30545

Written By :
 Checked & Approved By :
 Comment : Est D powder

Additional Product

Job Number:

Seq. #: Machine Or Op

1.0 D2423

Comment: Qty.: 0.071
 Lug Extrusion
 D2423
 Batch:

2.0 BAND SAW

Comment: Band Saw
 Cut D2423 ext
 Batch:

3.0 HAAS1

Comment: HAAS CNC V
 Machine per f
 Check for crack

4.0 QC2

Comment: INSPECT PA

5.0 QC8

Comment: SECOND CH

Monday, 05/03/2007 12:34:27 PM
 Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30993

Part Number: D22303

Job Number:

Seq. #: Machine Or Operation:

Description:

5.0 QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0 QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT INSPECT POWDER COAT

11.0 PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

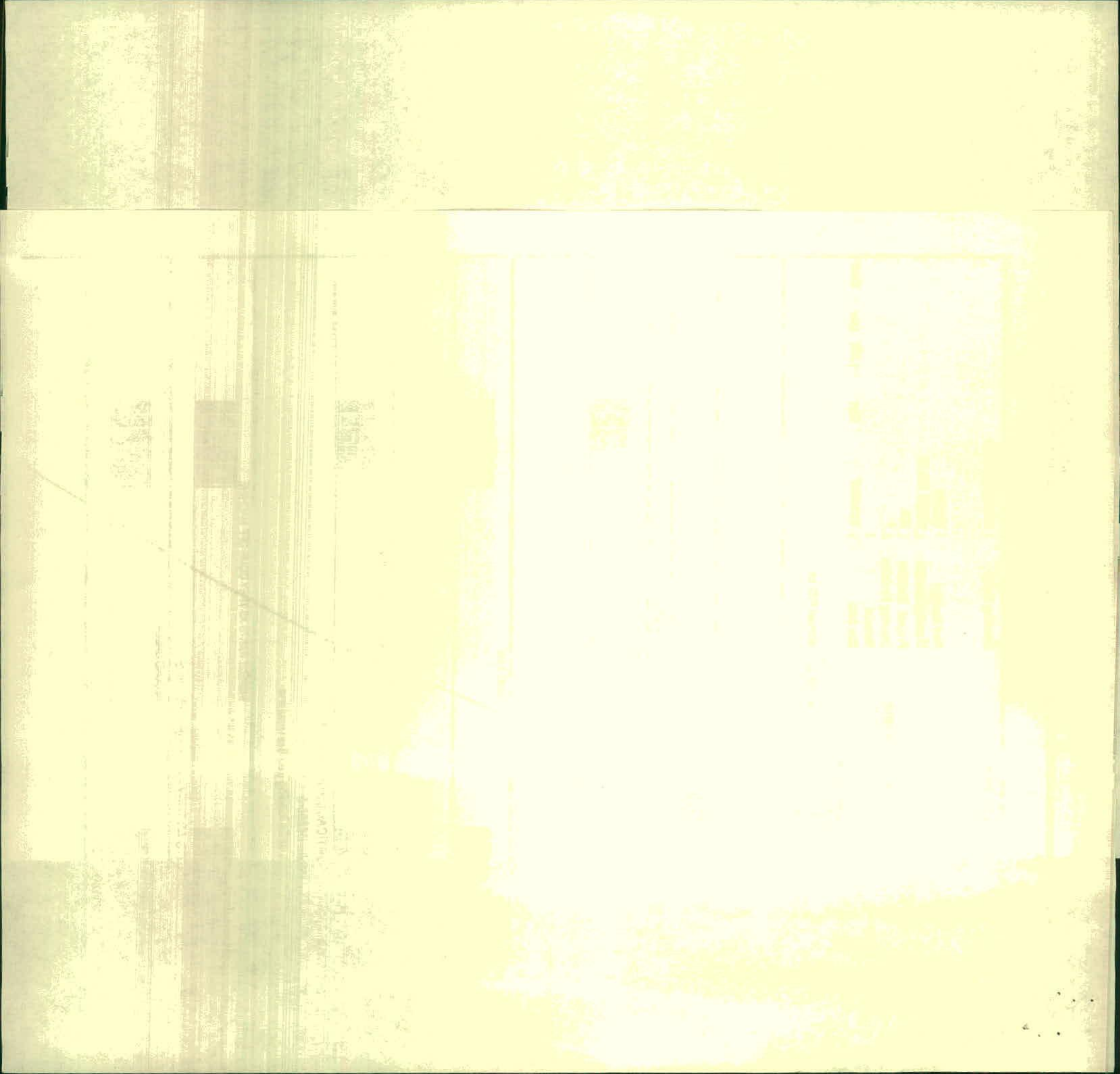
Location:

12.0 QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Thursday, 3/1/2007 11:34:00 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30993

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



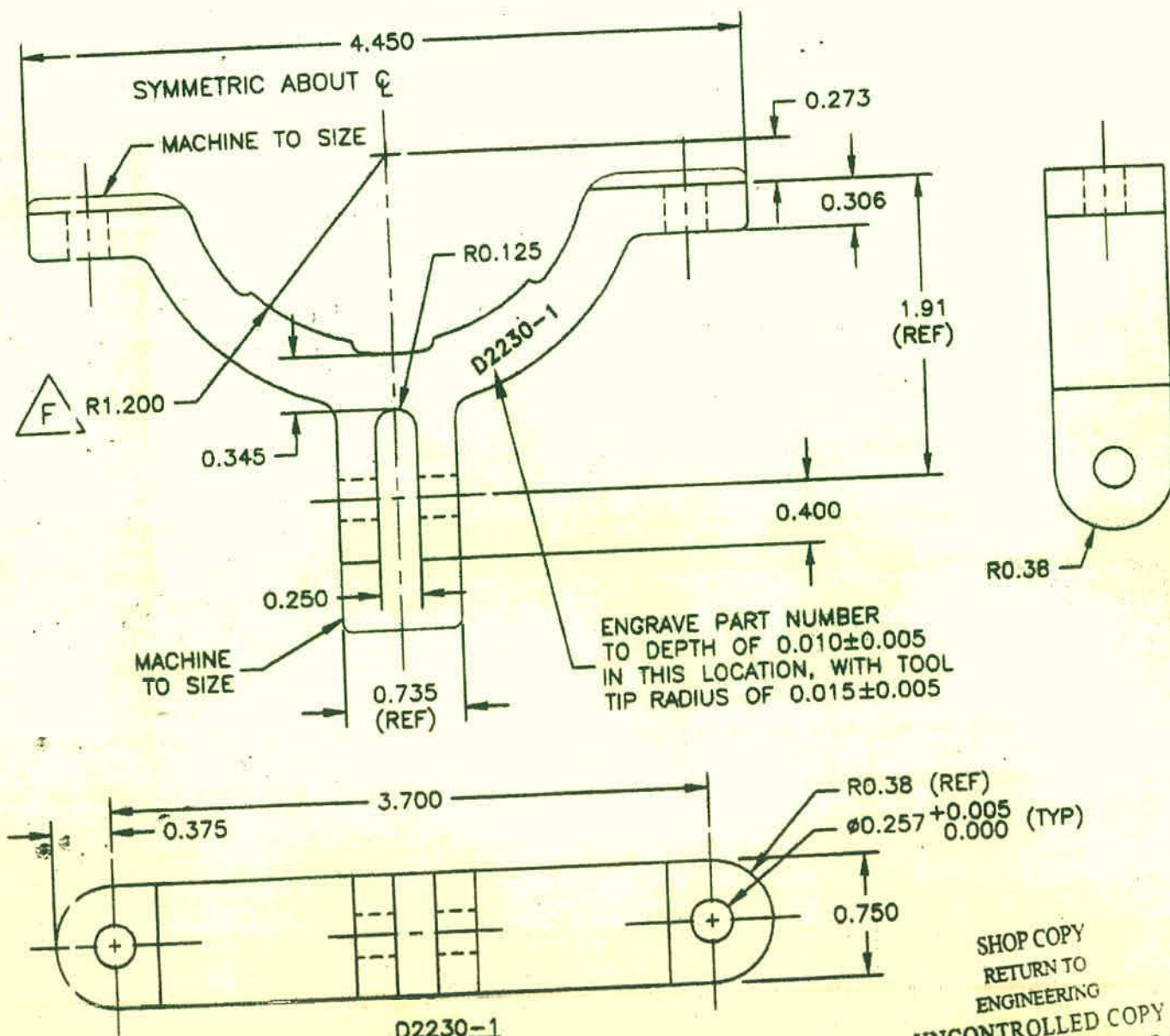
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED	#	APPROVED	#	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
99.12.21 PS

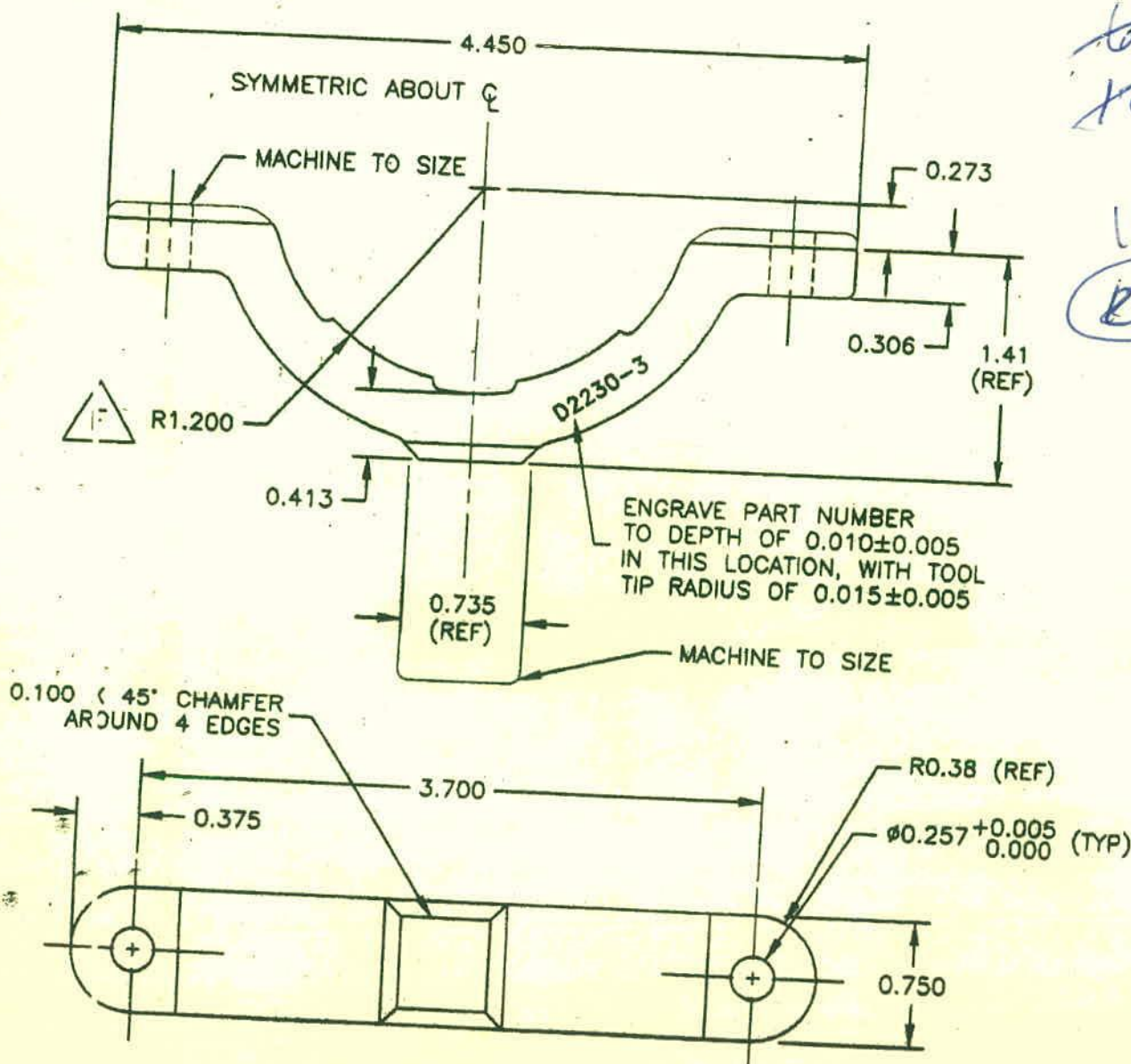
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30993



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2230	REV. F
DATE 99.12.13		TITLE MOUNTING LUG	SHEET 2 OF 2
		SCALE 1:1	

RELEASED
19.12.21 DS



180
219

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FIN SH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **30993**



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

220

D2230-3


Lug

BLKT0001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METALC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 27, 2007



